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D4776-3

Job Sheet 189520



Part No: D4776-3

Job Qty: 30 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4776 REV:E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	2/12/19	2/12/19	0.00	0.00	Start Up Machining-3		<i>mmk 19/02/19</i>
100	Bandsaw	30 pcs	2/12/19	2/12/19	0.00	0.54	Bandsaw1		<i>mmk 19/02/19</i>
110	CNC Vertical Machining	30 pcs	2/12/19	2/12/19	0.26	26.09	HAAS1-5		<i>mmk 19/02/19</i>
120	QC	30 pcs	2/12/19	2/12/19	0.00	0.00	QC2 Machining-3		<i>11</i>
130	QC	30 pcs	2/12/19	2/12/19	0.00	0.00	QC8 Machining-3		<i>11</i>
140	HandFinish	30 pcs	2/12/19	2/12/19	0.00	0.79	HandFinish1		<i>11</i>
150	QC	30 pcs	2/12/19	2/12/19	0.00	0.00	QC7-4		<i>11</i>
160	Powdercoat	30 pcs	2/12/19	2/12/19	0.00	0.37	Powdercoat1		<i>11</i>
170	QC	30 pcs	2/12/19	2/12/19	0.00	0.00	QC3		<i>11</i>
180	Packaging	30 pcs	2/12/19	2/12/19	0.00	0.00	Packaging3-2		<i>11</i>
190	QC21-SA	30 Ea	2/12/19	2/12/19	0.00	0.00	QC21		<i>11</i>

Part Op 100 - Cut Blank at 4.00" *4.625*

Descriptions: 110 - 1-Machine per folio EB168 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges

160 - START TIME: *7:55* OVEN TEMPERATURE: *320°* FINISH TIME: *8:25**M 138997*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	11.5800 ft (.386 ea)	90-Start up Operation	<i>S 150 600</i>

Job Allocations

Required	Inventory	Allocated
12	0	0



Container No: S152840



Part: D4776-3

Job No: 189520

Serial No/Batch: S152840

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/12/19

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430Inches $\pm$ 0.030	4.460 4.400	4.434	
2	Skidtube Clevis	2.300Inches $\pm$ 0.030	2.330 2.270	2.300	
3	Skidtube Clevis	1.778Inches $\pm$ 0.010	1.788 1.768	1.778	
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850	0.88	
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 + 0.010 - 0.000	0.520 0.510	0.510	
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053	1.062	
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350	1.380	
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	0.190	
9	Skidtube Clevis	0.100Inches $\pm$ 0.010	0.110 0.090	0.100	
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 + 0.006 - 0.001	0.490 0.483	0.484	Diameter
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	0.500	
12	Skidtube Clevis	0.640Inches $\pm$ 0.030	0.670 0.610	0.640	
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140	3.148	
14	Skidtube Clevis	1.080Inches $\pm$ 0.010	1.090 1.070	1.08	
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678	0.685	
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 + 0.006 - 0.001	0.403 0.396	0.397	Diameter
17	Skidtube Clevis	1.863Inches $\pm$ 0.010	1.873 1.853	1.861	
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	0.19	Radius
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	0.13	Radius
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	0.44	Radius
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115	0.123	
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	0.25	Radius
25	Skidtube Clevis	1.050Inches $\pm$ 0.030	1.080 1.020	Product 1.049	
26	Skidtube Clevis	1.430 $\pm$ 0.030		1.428	
27	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	Product 1.11	
28	Skidtube Clevis	0.060 $\pm$ 0.030		Product 0.06	
29	Skidtube Clevis	0.810Inches $\pm$ 0.030	0.840 0.780	Product 0.810	
30	Skidtube Clevis	0.060 $\pm$ 0.030		Product 0.600	
31	Skidtube Clevis	0.183Inches $\pm$ 0.010	0.193 0.173	Product 0.183	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					